

Work Order ID 151946

Friday, October 14, 2016 1:55:49 PM

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Item ID: D3847-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 10/19/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	D								

100

0.00

100

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: DProg Rev: D

2-Deburr if necessary

(12)

Dec 16/10/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(12)

Dec 16/10/22

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.03

Quality Control

DAS
38
9-89

OCT 17 2016

130

0.03

130

Brake NC

Memo

0.13

Brake NC

Form as per dwg

DAS
30
9-89

OCT 27 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.03

Quality Control

DAS
38
9-89

OCT 28 2016

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Item ID: D3847-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 10/19/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Memo Weld hardcoat as per dwg A/R 8259 Batch: <u>M135057</u>	0.00 0.13				<u>12</u>	<u>02</u>	<u>16/11-3</u>	
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>12</u>			DAS 38 NOV 03 2016
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.03				<u>12</u>			DAS 38 NOV 03 2016

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10

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
193		0.00							
193						12			
HandFinish	Memo	0.40							
Hand Finishing	APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG								3-11-16
	TEXTURE COATING BATCH: 135403								
196	QC3- Inspect Part Finish	0.00							
196						12			DAS 38 9-89
QC	Memo	0.02							
Quality Control									NOV 04 2016
200	Identify as per dwg & Stock Location: _____	0.00							
200						12			NOV 07 2016
Packaging	Memo	0.02							DAS 6 9-89
Packaging	LOCATION : FP001								

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Required Date: 10/24/2016 **Req'd Qty:** 10.00 ***10*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210 QC	Memo	0.17							
Quality Control									

DAS
21
9-89
NOV 17 2016

Handwritten signature and date: 16-11-7